

Item	Qty	Part Number	Description
1	X	D407-667-145	CROSSTUBE ASSEMBLY (407 HIGH FWD)
2	1	D6010-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2
10	2	AN742D36	CLAMP
11	2	MS9165-05	ANGLE BRACKET
12	2	MS21042L3	NUT (OR MS21042-3)
13	2	MS27039-1-08	SCREW
14	4	NAS1149C0332R	WASHER (OR AN960C10L)

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GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6010-115
FINISHED LENGTH = 113.20 ± 0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D407-667-145" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 17.8 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) TO INSTALL D2891-1 SUPPORT: ABRADE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.
- 16) MASK AREA UNDER CLAMP PRIOR TO PAINTING.
- 17) SEAL EDGES WHERE AN742D36 CLAMP MEETS WITH THE CROSSTUBE USING SIKAFLEX-241/-291 OR MIL-S-8802 CLASS B2 OR PROSEAL 890 SEALANT.
- 18) PERFORM RESISTANCE CHECK TO ENSURE MAX RESISTANCE IS 10 MILLIOHMS.

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2018 SEP 06
RN18-717

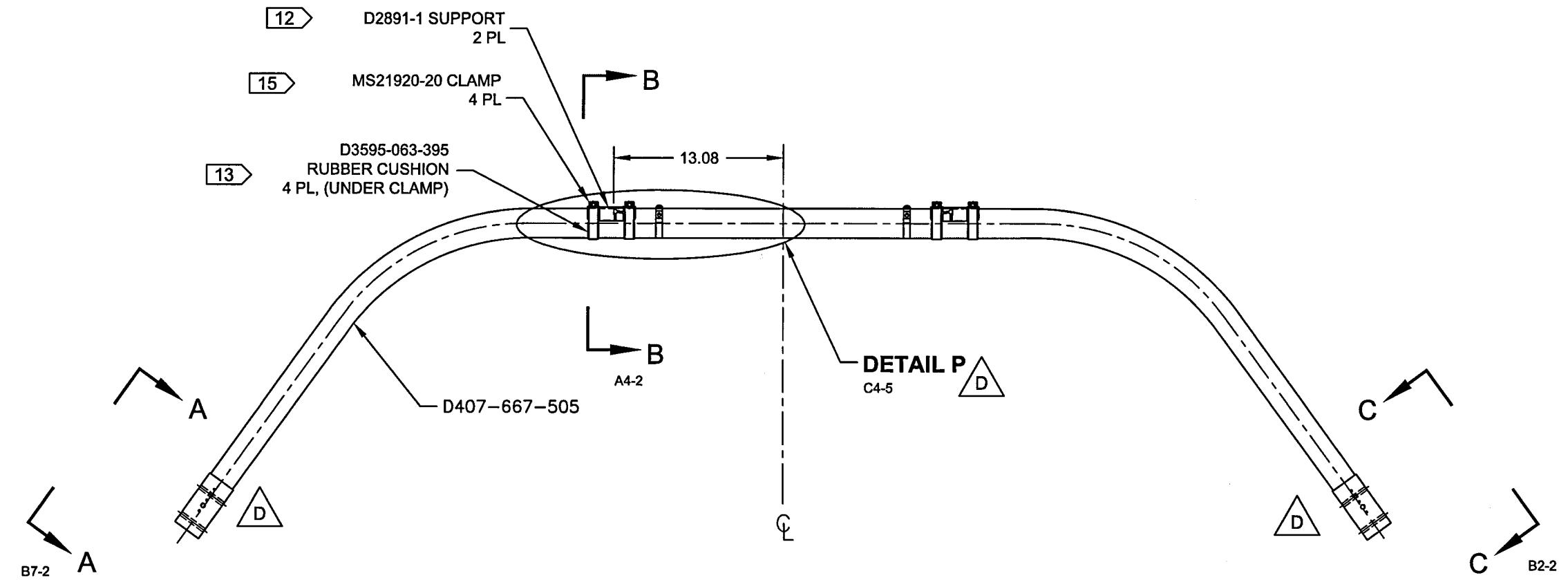
REV.	DESCRIPTION	BY	DATE
DESIGN	97		
DRAWN	JMH		
CHECKED	ZF		
MFG. APPR.	DF8		
APPROVED	NO		
DE APPR.	IP		
DATE	18.05.01		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

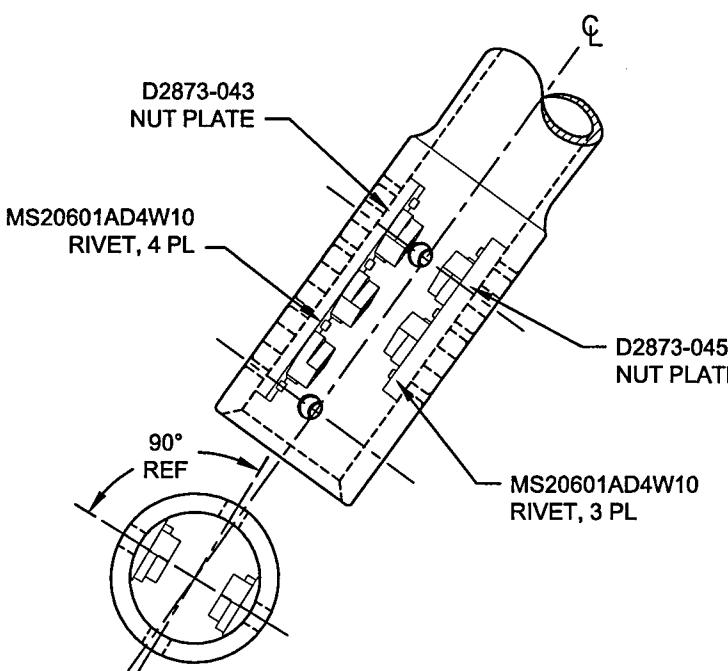
DRAWING NO. D407-667-145
REV. D
SHEET 1 OF 5

TITLE CROSSTUBE ASS'Y (407 HIGH FWD)
SCALE NTS

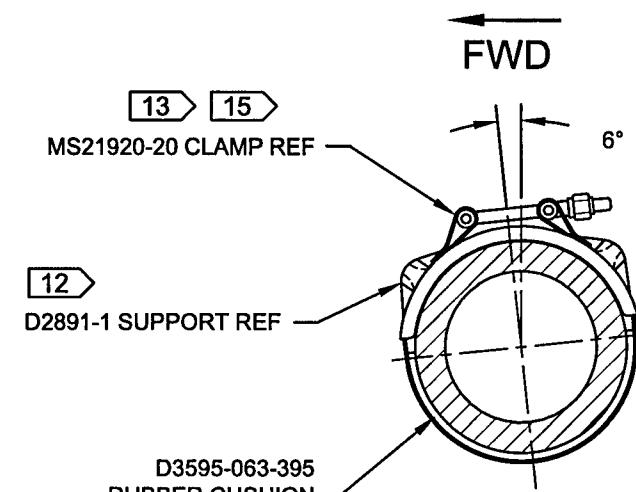
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D407-667-145
ASSEMBLY DETAIL
(VIEW LOOKING FWD)



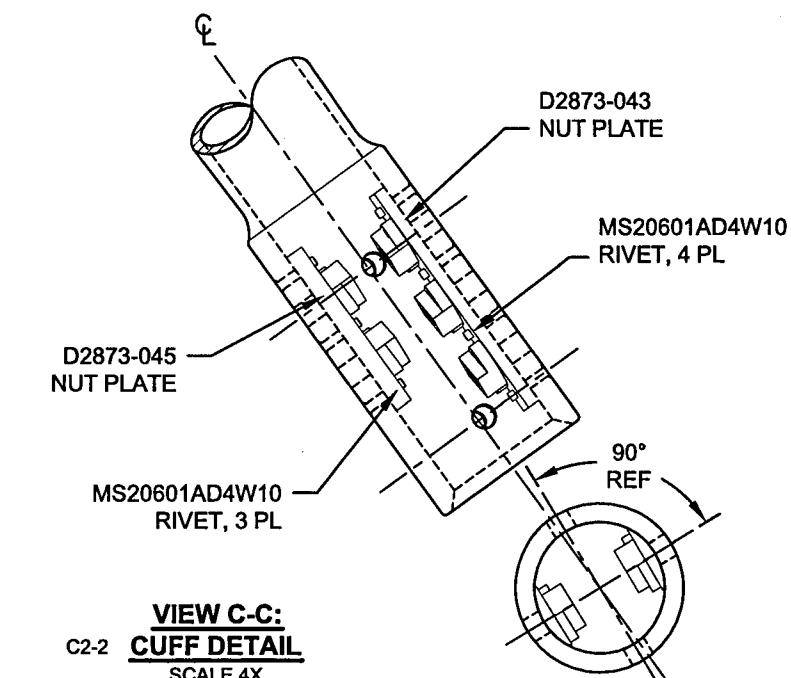
VIEW A-A:
CUFF DETAIL
SCALE 4X



D5-2 SECTION B-B
SCALE 5X

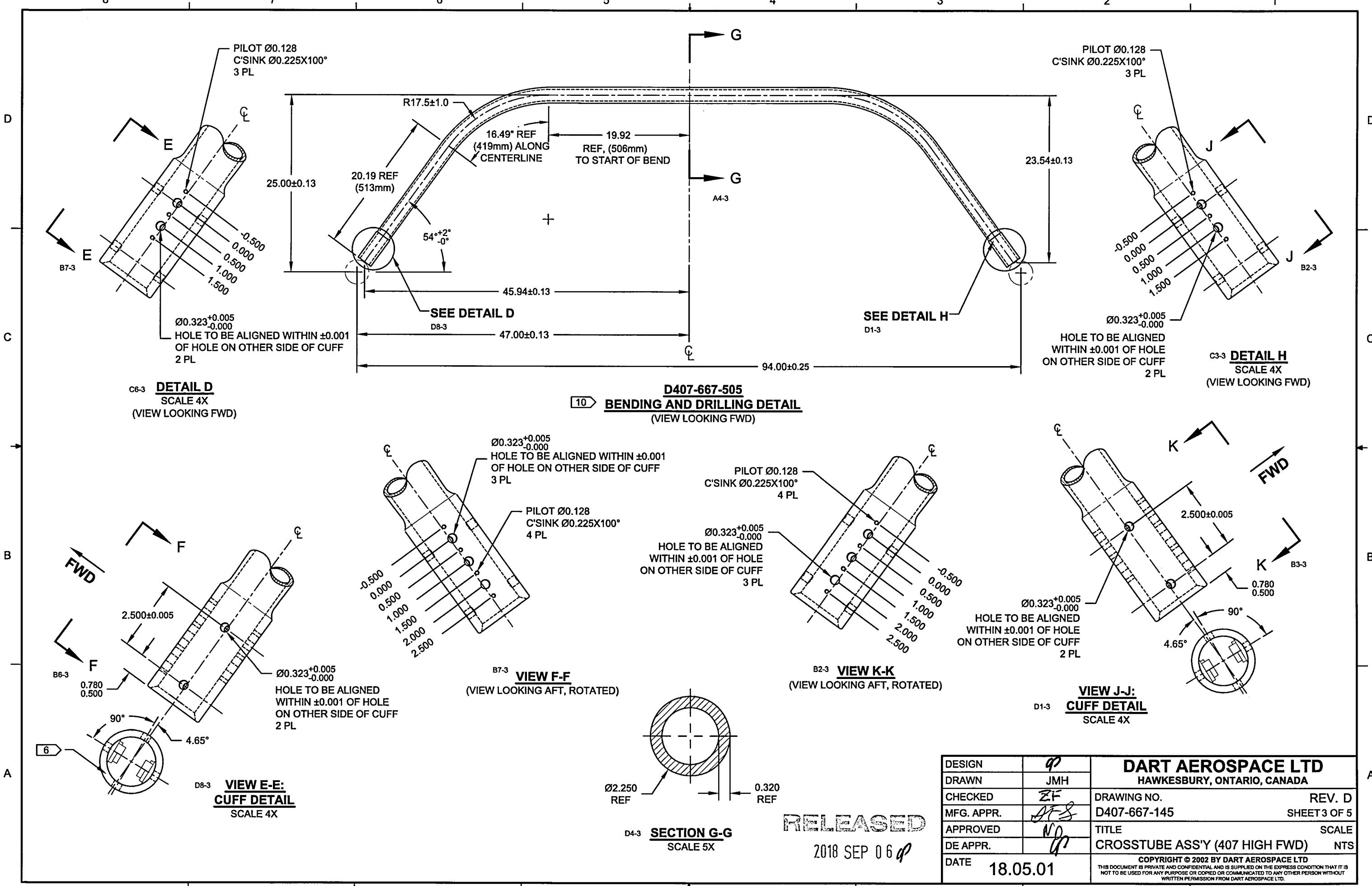
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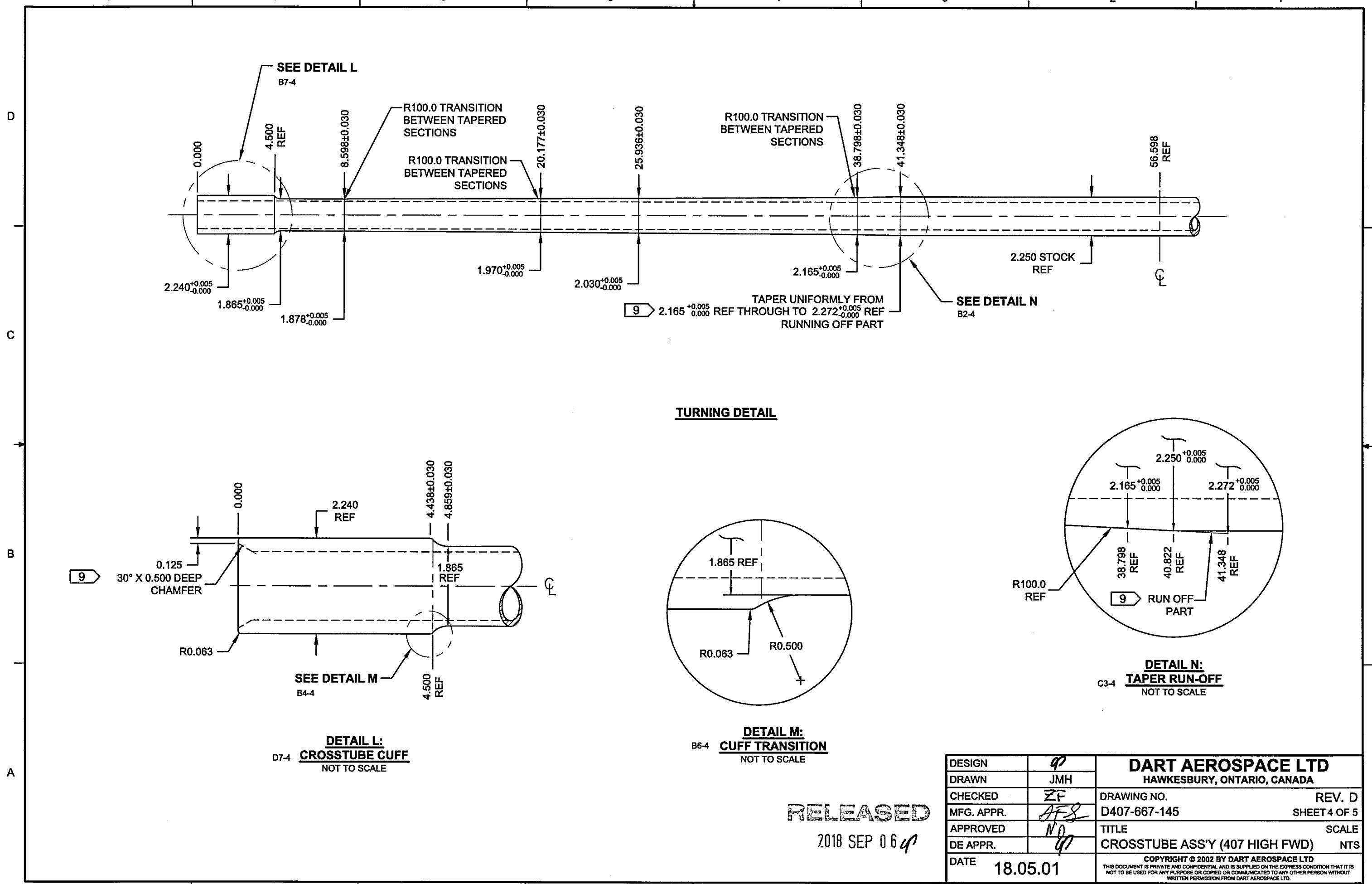


C2-2 VIEW C-C:
CUFF DETAIL SCALE 4X

DESIGN	<i>q</i>	DART AEROSPACE LTD	
DRAWN	JMH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ZF</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>AES</i>	D407-667-145	SHEET 2 OF 5
APPROVED	<i>NO</i>	TITLE	SCALE
DE APPR.	<i>q</i>	CROSSTUBE ASS'Y (407 HIGH FWD)	NTS
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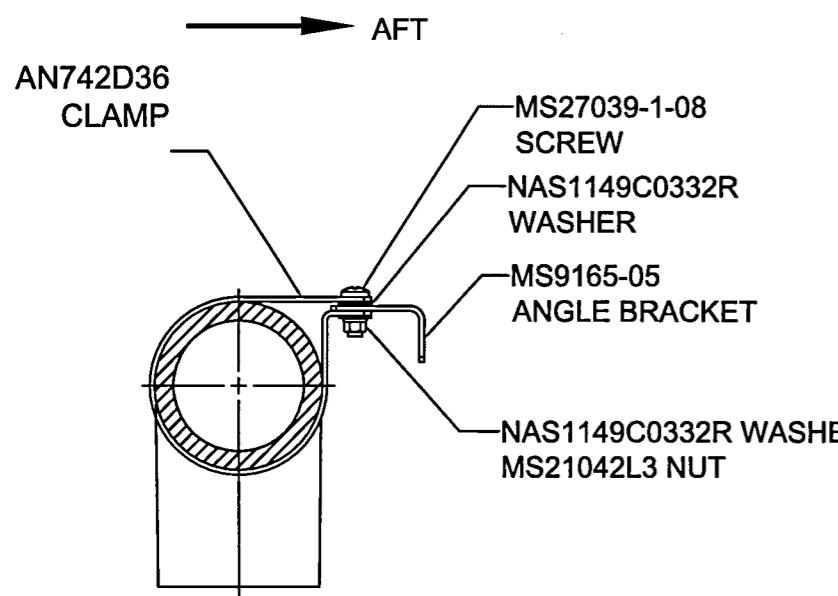
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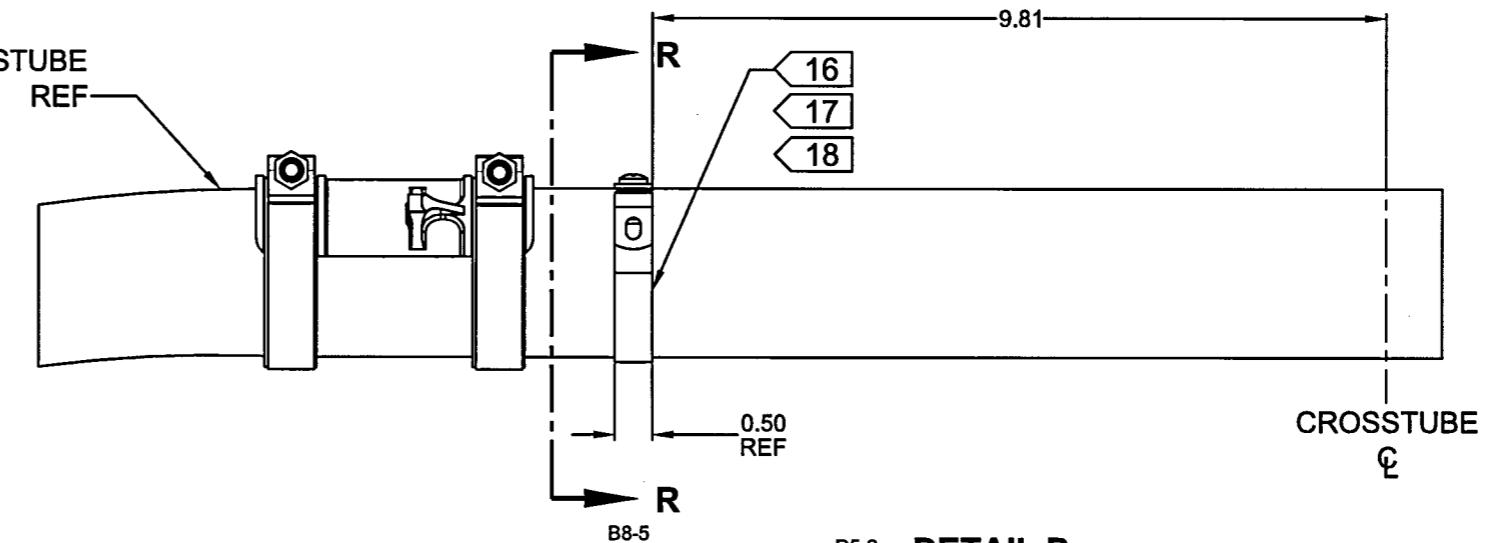
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D407-667-505 CROSSTUBE

REF



C4-5 **SECTION R-R**



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2018 SEP 06 4P

DESIGN	9P	DART AEROSPACE LTD	
DRAWN	JMH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	DRAWING NO.	
MFG. APPR.	AFS	D407-667-145	REV. D
APPROVED	ND	SHEET 5 OF 5	
DE APPR.	9P	TITLE	SCALE
DATE	18.05.01	CROSSTUBE ASS'Y (407 HIGH FWD)	NTS
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